

Date: Monday, 09/02/2009 4:29:26 PM
User: Melanie Fauteux











Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT BLADE FOLD ASSEMBLY
Job Number :	45648		
Estimate Number :	13532		
P.O. Number :		Part Number :	PB674300103
This Issue :	09/02/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 P.1,3,4,15
First Issue :	/ /	Project Number :	N/A
Previous Run :	45647	Drawing Revision :	B1
	Type :	Material :	
	SMALL /MED FAB	Due Date :	30/04/2009
Written By :		Qty:	2
Checked & Approved By :	<u>MF 09-03-10</u>	Um:	Each
Comment :	Est Rev:A 08-07-30 new issue DD verified by:ec Est Rev:B 08-12-04 up date part list DD Verified by:ec		

Additional Product


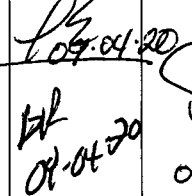
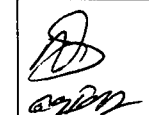
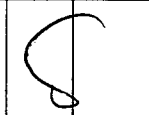
Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PB674300109	Aft Blade Fold Assembly Weldment
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Aft Blade Fold Assembly Weldment batch: <u>B 45046</u>		
		<u>MF 09-04-23</u>
2.0	PB674300113	Aft Adjustable Blade Support Assembly
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Aft Adjustable Blade Support Assembly batch: <u>45042</u>		
		<u>MF 09-04-23</u>
3.0	PB674300117	Aft Adjustable Blade Support Assembly
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Aft Adjustable Blade Support Assembly batch: <u>45040</u>		
		<u>MF 09-04-23</u>
4.0	PB674300121	PB67-43001-21
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) PB67-43001-21 batch: <u>45038</u>		
		<u>MF 09-04-23</u>
5.0	PB674300123	PB67-43001-23
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) PB67-43001-23 batch: <u>45035</u>		
		<u>MF 09-04-23</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: PB67-43001-03 PAR #: _____ Fault Category: Prod / Insp. Lg NCR: Yes No DQA: D Date: 09/04/08
 Resolution: re-work Disposition: _____ QA: N/C Closed: D Date: 09/04/09

NCR: <u>45648</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/4/20	# 10	Both PB6743001-07 B2 45046 were found with the welds not ground before powder coat R.C. missed @ inspection and welder forgot. Lack of Attention		Buff welds + de-burr Re powder coat as per AS1005	 09-04-20 01-04-20	 01/04/23	 09/04/20	

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:29:26 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45648

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB674300137

PB67-43001-37



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PB67-43001-37

batch: ~~45029~~ 45029 x 1, 40242 x 1

mf 09-04-23

7.0

PB674300157

Stabilizer Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Stabilizer Arm

batch: ~~45025~~ 45025

mf 09-04-23

8.0

PB674300159

PB67-43001-59



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PB67-43001-59

batch: 45024 x 1, 45801 x 1

mf 09-04-23

9.0

PB674300163

Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle Assembly

batch: 48023

mf 09-04-23

10.0

PB6743001135

Male Eye



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Male Eye

batch: B23995A x 1, 45000 x 1

mf 09-04-23

11.0

PB6743001155

Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

batch: 43092 x 2

mf 09-04-23

12.0

PB6743001261

Lever Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Lever Arm

batch: 1 x 467094, 3 x 44978

mf 09-04-23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:29:26 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45648

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PB6743001265

Bushing



Comment: Qty.: ~~5~~ 10.0000 Each(s)/Unit Total : ~~8~~ 10.0000 Each(s)

Bushing

batch: 46932

MF 09-04-23

14.0

PB6743001299

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bushing

batch: 43094

MF 09-04-23

15.0

PB6743001305

Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bearing

batch: 41886

MF 09-04-23

16.0

D3451045

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle and Lock-Down Assembly

batch: 47047 x 1, 45309 x 1

MF 09-04-23

17.0

D3451043

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle and Lock-Down Assembly

batch: 45308

MF 09-04-23

18.0

D34401

Tube Guide (Supersedes B67-43001-25/-307)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Tube Guide

batch: 41347

MF 09-04-23

19.0

D34403

Clamp (Supersedes B67-43001-309)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp

batch: 41348

MF 09-04-23

Date: Monday, 09/02/2009 4:29:26 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45648

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D34441

Velcro Loop Belt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Velcro Loop Belt
batch: 41349

MF 09-04-23

21.0

D34491

Pad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pad

batch: 415287

MF 09-04-23

22.0

D34479

Swing Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Swing Arm

batch: 41352x2, 46263x2

MF 09-04-23

23.0

086004

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inventory

batch: m109350

MF 09-04-23

24.0

MS27039107

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: m18106

MF 09-04-23

25.0

MS27039123

SCREW



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

SCREW

batch: m18057

MF 09-04-23

26.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 26.0000 Each(s)

Nut

batch: m109282

MF 09-04-23

Date: Monday, 09/02/2009 4:29:26 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45648

Part Number: PB674300103

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

27.0	MS21042L6	Nut
------	-----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

batch: m110002

mf 09-04-23

28.0	MS518596	WASHER
------	----------	--------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

batch: m108986

mf 09-04-23

29.0	MS518598	WASHER
------	----------	--------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

batch: m108987

mf 09-04-23

30.0	NAS43DD368	SPACER
------	------------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

SPACER

batch: m10983

mf 09-04-23

31.0	NAS1149F0316P	WASHER
------	---------------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

batch: 111124

mf 09-04-23

32.0	NAS1149F0432P	Washer
------	---------------	--------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

batch: m18057

mf 09-04-23

33.0	NAS1149F0632P	WASHER
------	---------------	--------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

batch: m18057

mf 09-04-23

Date: Monday, 09/02/2009 4:29:27 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45648

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

NAS1149F0832P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

batch: m18057

MF 09-04-23

35.0

AN960JD6

Washer



Comment: Qty.: ⁵1.0000 Each(s)/Unit Total : ¹⁰2.0000 Each(s)

Washer

batch: m6085

MF 09-04-23

36.0

AN410A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: m108986

MF 09-04-23

37.0

AN413A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: m110731

MF 09-04-23

38.0

~~AN416A~~

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

batch: _____
or AN415A (see engineering) batch: m110399

MF 09-04-23

39.0

AN611A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

batch: m105558

MF 09-04-23

40.0

~~AN620A~~

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: _____
or AN616A (see engineering) batch: m11119x4

MF 09-04-23

~~AN6C16A x 1 B105831~~

Date: Monday, 09/02/2009 4:29:27 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45648

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

AN813A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

batch: m110915

mf 09-04-23

42.0

BSP43

RIVET



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

RIVET

batch: m109119

mf 09-04-23

43.0

CR3213405

cherry rivet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

cherry rivet

batch: m108473

mf 09-04-23

44.0

MS17984C413

PIN, QUICK RELEASE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PIN, QUICK RELEASE

batch: m11119
or MS17984C410 (see engineering) batch: m11119

mf 09-04-23

45.0

MS17984C418

PIN, QUICK RELEASE



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

PIN, QUICK RELEASE

batch: m111060 x 2, m111359 x 4

mf 09-04-23

46.0

30345T21

LANYARD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

LANYARD

batch: m17828

mf 09-04-23

47.0

30345T24

LANYARDS



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

LANYARDS

batch: m108913

mf 09-04-23

Date: Monday, 09/02/2009 4:29:27 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45648

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

48.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 9.0000 Each(s)/Unit Total: 18.0000 Each(s)

SPRING SLOTTED PIN

batch: m111088

mk 09-04-23

49.0

3408A98

DETENT BALL SPRING PLUNG



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

DETENT BALL SPRING PLUNG

batch: m108390

mk 09-04-23

50.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2.

242 THREADLOCK batch: _____

mk 09-04-21

Last page

56.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/04/23 (x2)

57.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPP 45-648 09/19/23

58.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/24

Job Completion



mk 09-04-24

Date: Tuesday, 10/03/2009 2:12:39 PM
 *User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT BLADE FOLD ASSEMBLY
Job Number : 45648	
Estimate Number : 13532	
P.O. Number :	Part Number : PB674300103
This Issue : 10/03/2009 S.O. No. :	Drawing Number : B6743001 P.1,3,4,15
Prsht Rev. : NC	Project Number : N/A
First Issue : 09/02/2009 Type : SMALL /MED FAB	Drawing Revision : B1
Previous Run : 45647	Material :
Written By :	Due Date : 30/04/2009 Qty: 2 Um: Each
Checked & Approved By : <u>mf 09-0310</u>	
Comment : Est Rev:A 08-07-30 new issue DD verified by:ec Est Rev:B 08-12-04 up date part list DD Verified by:ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

50.0	MS24694S102	Screw
------	-------------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Screw m14604

mf 09-04-23

51.0	AN526A	BOLT
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 BOLT m18057

mf 09-04-23

52.0	MS518597	Washer
------	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Washer m110193

mf 09-04-23

53.0	NAS1149F0532P	WASHER
------	---------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
 WASHER m18057

mf 09-04-23

54.0	MS21042L5	Nut
------	-----------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Nut m109840

mf 09-04-23

Job Completion



Date: Tuesday, 21/04/2009 3:30:13 PM
 User: Linda Lacelle



Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT BLADE FOLD ASSEMBLY
Job Number	: 45648		
Estimate Number	: 13532		
P.O. Number	:	Part Number	: PB674300103
This Issue	: 21/04/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: B6743001 P.1,3,4,15
First Issue	: 09/02/2009	Project Number	: N/A
Previous Run	: 45647	Drawing Revision	: B1
		Material	:
Written By	:	Due Date	: 30/04/2009
Checked & Approved By	: <u>ME 09-04-21</u>	Qty:	2
Comment	Est Rev:A 08-07-30 new issue DD verified by:ec Est Rev:B 08-12-04 up date part list DD Verified by:ec		

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

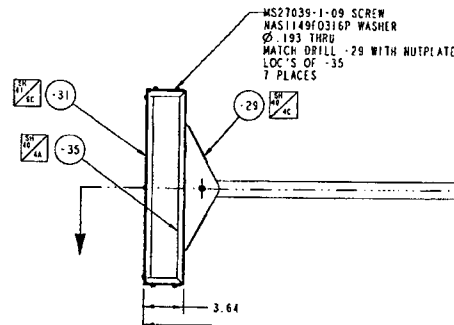
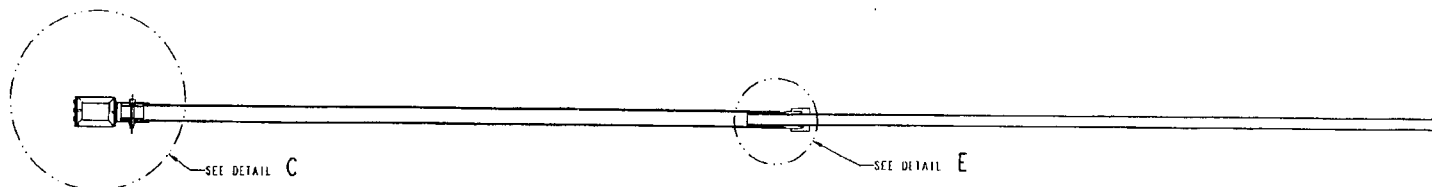
55.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2. 242 THREADLOCK batch: <u>M109687</u>		

Job Completion 

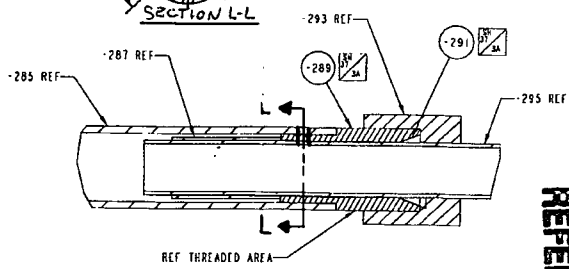
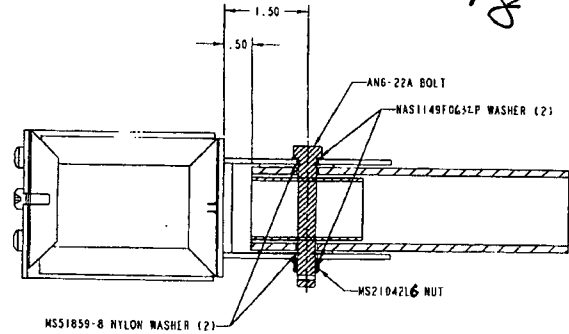
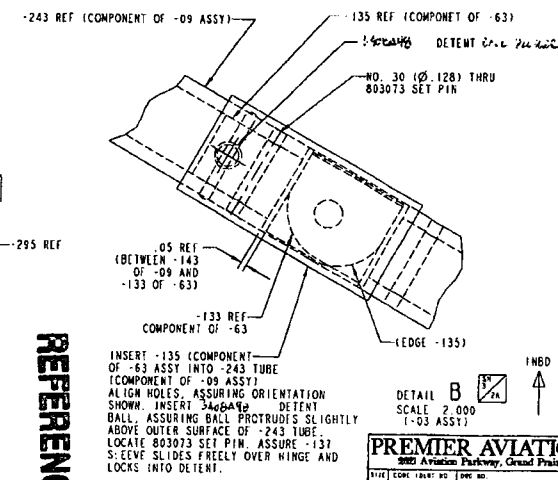
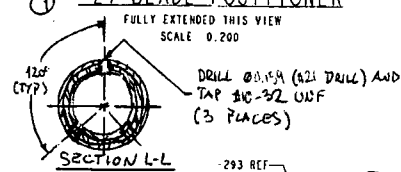
126201W



RELEASED
46 JUL 2 1954



① -27 BLADE POSITIONER

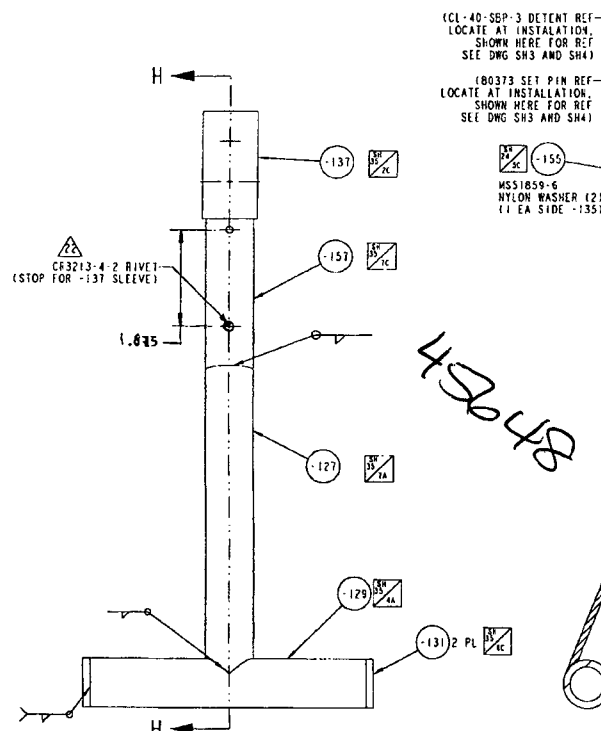
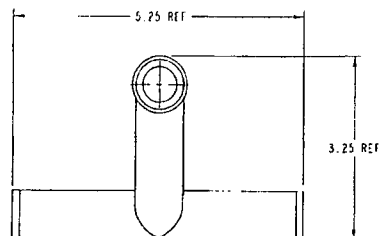


INSERT -135 (COMPONENT OF -63 ASSY) INTO -243 TUBE (COMPONENT OF -09 ASSY) ALIGN HOLES, ASSURING ORIENTATION SHOWN. INSERT 803073 DETENT BALL, ASSURING BALL PROTRUDS SLIGHTLY ABOVE OUTER SURFACE OF -243 TUBE. LOCATE 803073 SET PIN. ASSURE -137 SLEEVE SLIDES FREELY OVER HINGE AND LOCKS INTO DETENT.

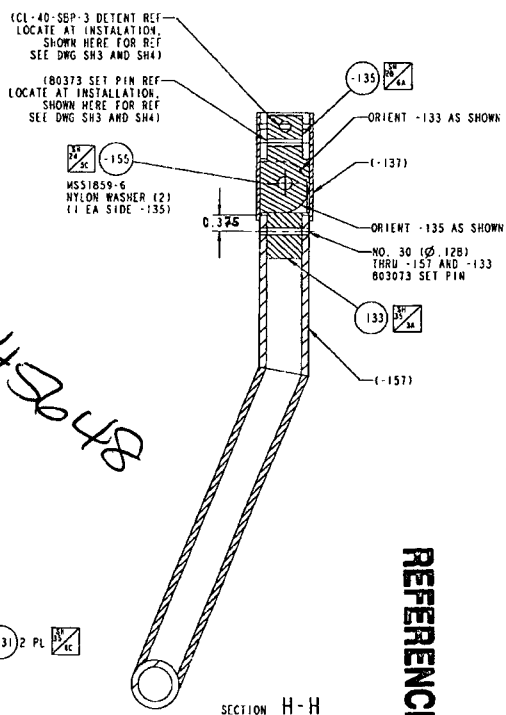
PREMIER AVIATION, INC.
8001 Aviation Parkway, Grand Prairie, Texas 75052
D: OSUV8 B67-43001

REFERENCE ONLY

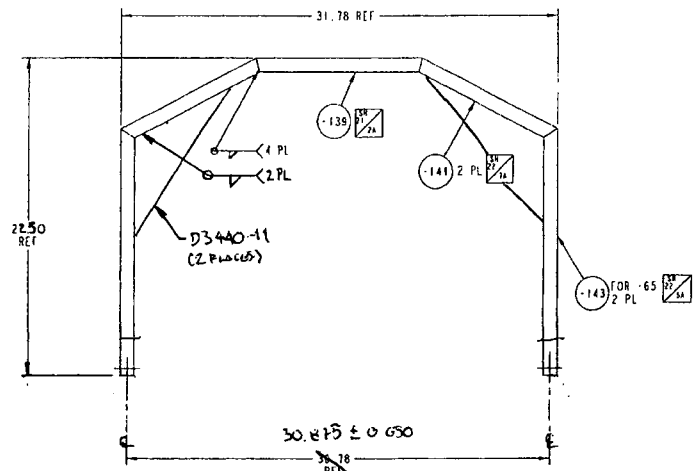
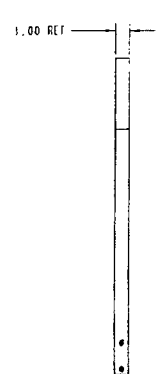
ORIGINAL



① -63 SHORT T-HANDLE ASSEMBLY
SCALE 1.000

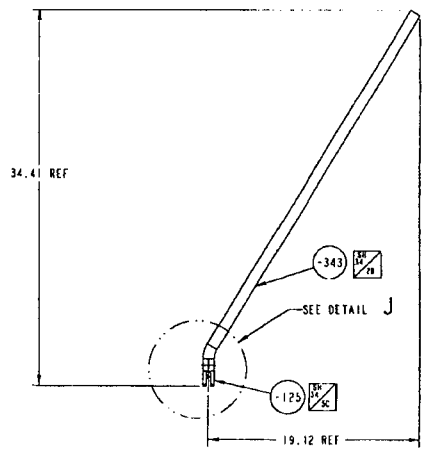


REFERENCE ONLY

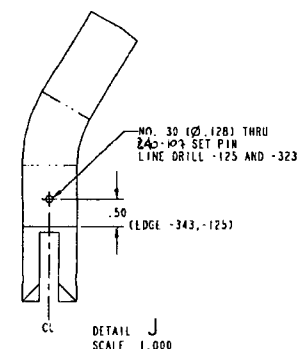


RELEASED
06 JUL 70

① -47 BASE ASSEMBLY (SHOWN)
(COMMERCIAL VERSION)
SCALE 0.250
① -47 BASE ASSEMBLY (SAME, EXCEPT AS SHOWN)
(CANADIAN VERSION)



① -37 TUBE ARM ASSEMBLY
SCALE 0.700



PREMIER AVIATION, INC.
2000 Aviation Parkway, Grand Prairie, Texas 75050
D OSUV8 B67-43001
SCALE: 1:1 SHEET 15 OF 45

ORIGINAL